



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4272-012
Job Sheet 190451



Part No: D4272-012

Job Qty: 1 pcs

Part Name: Basket Assembly, Heavy Duty Lid, RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/8/19

Job Tracking No:

Due Date: 3/29/19

Created By: Jesse White

Type: Stock

Description: SIOP

Note: DWG REV D IPP Rev:A 10.11.19 new issue DD verf:EC IPP Rev:B 11.01.20 AS PER DWG REV.C DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Packaging 1 - Pick Kit	1 pcs		3/29/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S174048

Part: D4272 - 012

Job No: 190451

Serial No/Batch: S174048

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/22/19

Plex 2/8/19 1:16 PM dart.white.jesse

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
110	Handfinish - 4-1-Assembly-B4B	1 pcs	3/29/19	0.00 2.04	Handfinish - 4 - 1 - B4B	ME 19-4-23
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
120	QC 5	1 pcs	3/29/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
130	Packaging 3-1 - Stock - B4B	1 pcs	3/29/19	0.00 0.00		

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Entered: _____ Date: _____



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Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	F.D.
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
140	QC 21 - SA	1	3/29/19	0.00 0.00	QC 21 - SA - 21
		pcs			QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 100 - Pick Kit)

Descriptions: 110 - (Assemble as per dwg)TRANSFER DRILL FROM PLACARD INTO BASKET AS PER DWG ON SHEET 2
 ASSEMBLE USING BASE D4273-042 X 1B75294 FROM BASKET D407-797-014 X 1 B131540

120 - QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location:_____)

140 - (QC21- Final Inspection - Work Order Release)

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

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Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97447A010	Blind Rivet	4 pcs (4 ea)	100-Packaging 1 - Pick Kit	009362 5019014
AN3-10A	Bolt	3 Ea (3 ea)	100-Packaging 1 - Pick Kit	5157517-1
AN3-14A	Bolt	4 Ea (4 ea)	100-Packaging 1 - Pick Kit	5161920-1
AN3-16A	Bolt	2 Ea (2 ea)	100-Packaging 1 - Pick Kit	5149288-3
AN310-4	Nut	3 Ea (3 ea)	100-Packaging 1 - Pick Kit	5163228
AN310C4	Nut	3 Ea (3 ea)	100-Packaging 1 - Pick Kit	5156966
AN4-12	Bolt	3 Ea (3 ea)	100-Packaging 1 - Pick Kit	5116813-2
AN4-13A	Bolt	6 Ea (6 ea)	100-Packaging 1 - Pick Kit	5158578
AN4C15	BOLT	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	5119859
AN5-17A	Bolt	4 Ea (4 ea)	100-Packaging 1 - Pick Kit	5149141-2
D2530	Handle Weldment	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	5161901
D2535	Spring	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	5154034
D2537	Bushing	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	5123161
D2690-6 X	Lanyard	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	5186435
D2931	Bumper	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	5162049
D3912-041	Eyebolt Receiver Assembly	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	X 5167664
D3914-041	Long Basket Lid Assembly (350)	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	5170311
D3917-3	Washer	6 pcs (6 ea)	100-Packaging 1 - Pick Kit	5170157
D3953-17	Gas Spring Spacer	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	5166929
D3953-19	Gas Spring Bracket	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	5143335
D3953-21	Gas Spring Bracket	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	5150029
D3953-3	Gas Spring Stud, Lid	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	5163194
D3953-7	Spring Spacer	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	5163886
D3953-9	Gas Spring Washer	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	5159218
D3969-3	Spring (Basket Lid)	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	5148603
D4021-5	Blanking Plate	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	5150327
X D4150-041	Attachment Arm Assembly	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	5159143
D4151-041	Basket Fwd Hardpoint Assembly, Lower	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	5161498
D4151-043	Basket Fwd Hardpoint Assembly, Upper	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	5160584
D4273-042	Basket Base Assembly, RH	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	5170551
D4307-250	Placard, Max Load	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	5148261
MS17984-C413	Quick Release Pin	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	5167582
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	100-Packaging 1 - Pick Kit	5155667
MS21042L3	Nut	9 Ea (9 ea)	100-Packaging 1 - Pick Kit	5157462
MS21042L4	Nut	6 Ea (6 ea)	100-Packaging 1 - Pick Kit	506789
MS21042L5	Nut	4 Ea (4 ea)	100-Packaging 1 - Pick Kit	5149145-1
MS24665-151	Cotter Pin	4 Ea (4 ea)	100-Packaging 1 - Pick Kit	5144956
MS24665-300	Cotter Pin	2 Ea (2 ea)	100-Packaging 1 - Pick Kit	5157264
NAS1149C0432R	Washer	2 Ea (2 ea)	100-Packaging 1 - Pick Kit	5103990-1
NAS1149C0463R	Washer	3 Ea (3 ea)	100-Packaging 1 - Pick Kit	5104373
NAS1149DN832J	Washer	2 Ea (2 ea)	100-Packaging 1 - Pick Kit	5034411
NAS1149F0332P	Washer	14 Ea (14 ea)	100-Packaging 1 - Pick Kit	5155976
NAS1149F0432P	Washer	18 Ea (18 ea)	100-Packaging 1 - Pick Kit	5152652
NAS1149F0563P	Washer	4 Ea (4 ea)	100-Packaging 1 - Pick Kit	5098081
NAS1515H4L	Washer	2 Ea (2 ea)	100-Packaging 1 - Pick Kit	5044189

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

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Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Packaging 1 - Pick Kit	97447A010	4	675	0
	AN3-10A	3	211	0
	AN3-14A	4	263	0
	AN3-16A	2	77	0
	AN310-4	3	118	0
	AN310C4	3	92	0
	AN4-12	3	94	0
	AN4-13A	6	1,207	0
	AN4C15	1	49	0
	AN5-17A	4	183	0
	D2530	1	1	0
	D2535	2	47	0
	D2537	2	120	0
	D2690-6	2	85	0
	D2931	2	807	0
	D3912-041	1	8	0
	D3914-041	1	19	0
	D3917-3	6	74	0
	D3953-17	2	53	0
	D3953-19	1	41	0
	D3953-21	1	47	0
	D3953-3	2	67	0
	D3953-7	2	52	0
	D3953-9	2	43	0
	D3969-3	1	33	0
	D4021-5	1	32	0
	D4150-041	1	13	0
	D4151-041	1	13	0
	D4151-043	1	6	0
	D4273-042	1	0	0
	D4307-250	1	9	0
	MS17984-C413	2	46	0
	MS20600-AD4W3	2	139	0
	MS21042L3	9	2,712	0
	MS21042L4	6	3,135	0
	MS21042L5	4	867	0
	MS24665-151	4	556	0
	MS24665-300	2	29	0
	NAS1149C0432R	2	1,469	0
	NAS1149C0463R	3	429	0
	NAS1149DN832J	2	1,261	0
	NAS1149F0332P	14	3,006	0
	NAS1149F0432P	18	604	0
	NAS1149F0563P	4	512	0
	NAS1515H4L	2	220	0

Part Specifications

Specifications could not be found.

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